

Date: Monday, 6/5/2006 7:41:03 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER ASSEMBLY		
Job Number	: 27341-2		Part Number	: D314010		
Estimate Number	: 12368		Drawing Number	: D3140		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: D1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/30/2006 Qty: 2 Um: Each		
Previous Run	: N/A					
Written By	: <i>See comment below</i>					
Checked & Approved By	: <i>JK 06.05.1</i>					
Comment	: Est. A 06.04.19 New Issue KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D314085	Angle	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Angle Batch <i>027375-2</i>	<i>06.07.07(2)</i>
2.0	D314089	Doubler	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Doubler Batch <i>027376</i>	<i>06.07.05(2)</i>
3.0	MS20426AD34	RIVET	
		Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s) RIVET Batch <i>119099</i>	<i>06.07.07(2)</i>
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3140	<i>06.07.07(2)</i>
5.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>06.07.07(2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: 

Date: 06/07/08

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 6/5/2006 7:41:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 27341

Part Number: D314010

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 07/07/06 (2)

7.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/07/10 (2)

Job Completion



U 06/07/07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR NTS	
		A 02.04.18	NEW ISSUE
		B 03.01.23	REMOVE -65/-81/-83; ADD -301/-303
		C 04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°
		D 05.11.23	ADD -103/-104/-105/-106; REMOVE -67
		DI <i>[initials]</i> 06.03.31	1.75 WAS 1.88; 4.75 WAS 4.13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
1		1	1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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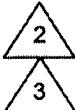
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DATE 05.11.23		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05-12-01 *[initials]*



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

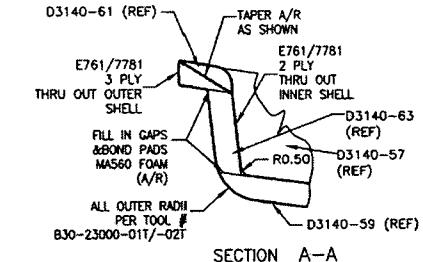
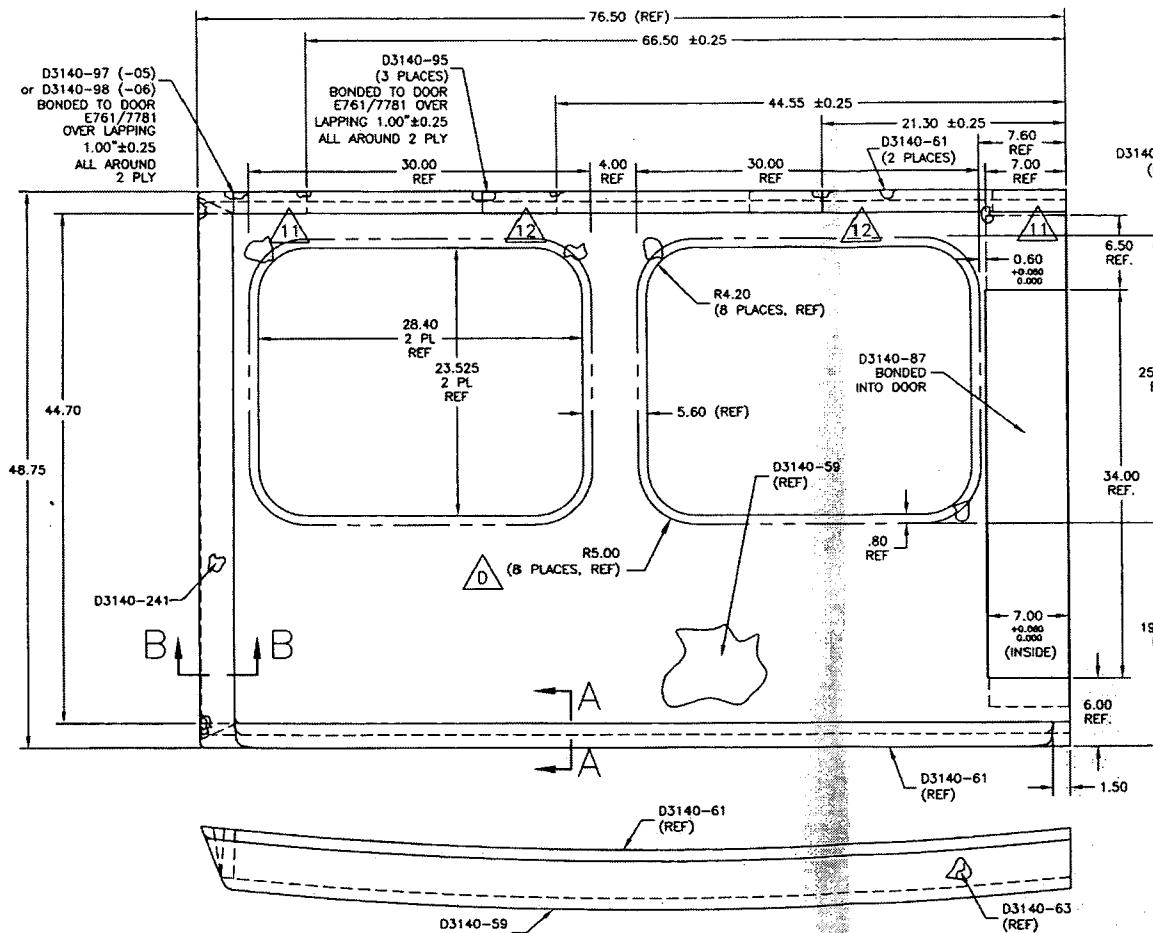


RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

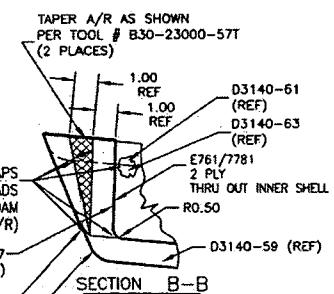
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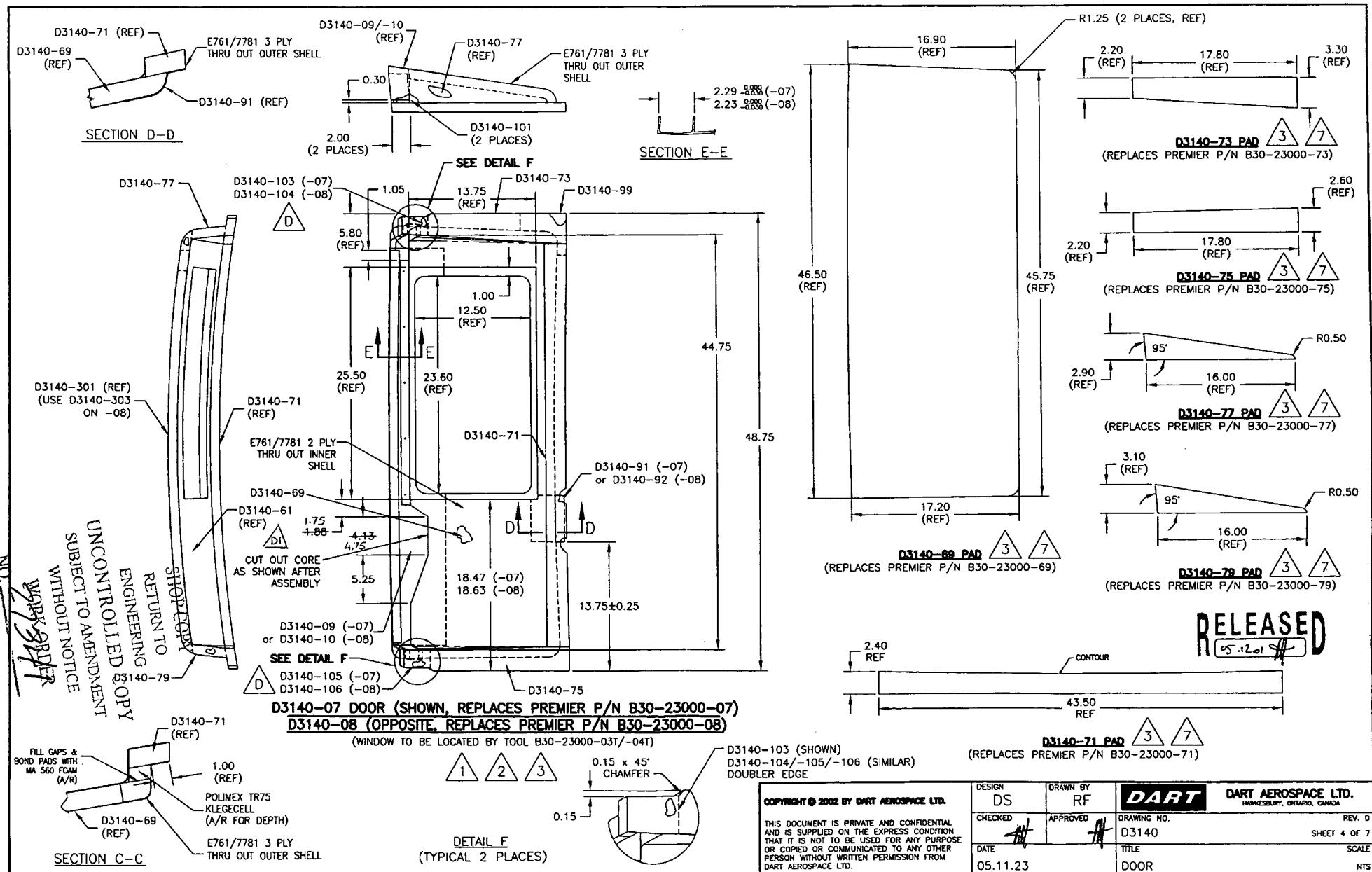
D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

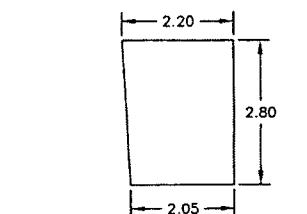
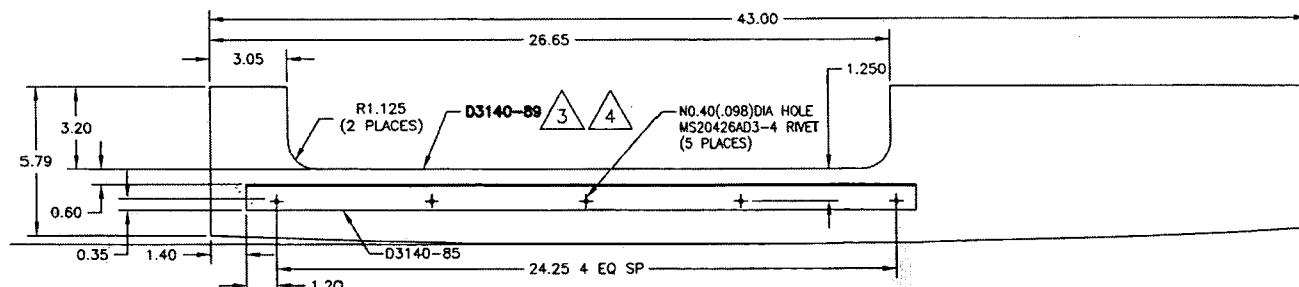
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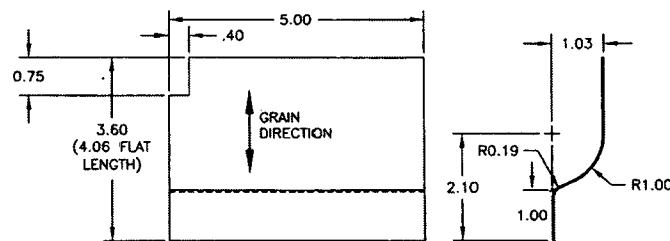
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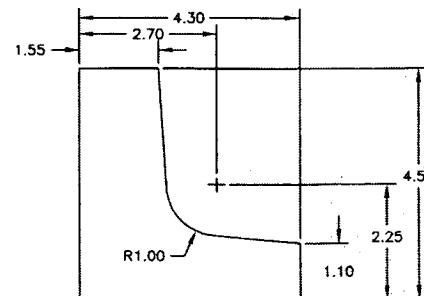


D3140-101 DOUBLER 4
(REPLACES PREMIER P/N B30-23000-101)

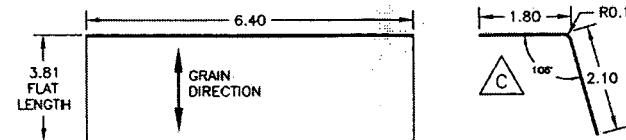


D3140-91F DOUBLER
(USE TO MAKE D3140-91/-92 DOUBLERS)

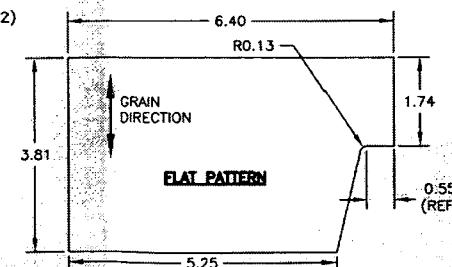
D3140-91 DOUBLER 4
(SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



D3140-98 DOUBLER 4
(REPLACES PREMIER P/N B30-23000-99)



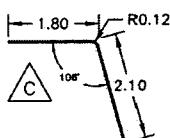
D3140-95 DOUBLER 4
(REPLACES PREMIER P/N B30-23000-95)



D3140-97F DOUBLER
(USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER 4
(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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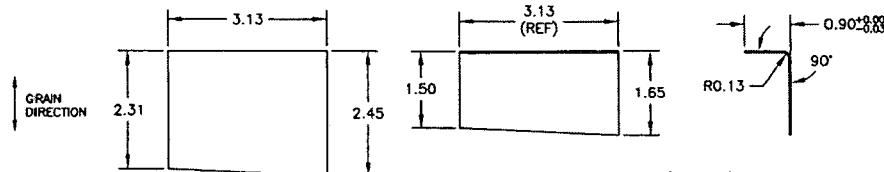
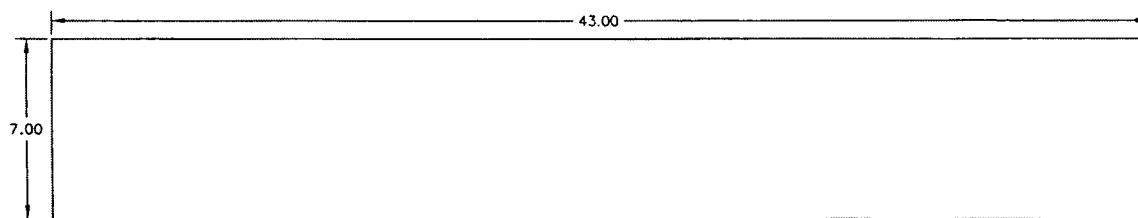
PEND. DETAIL

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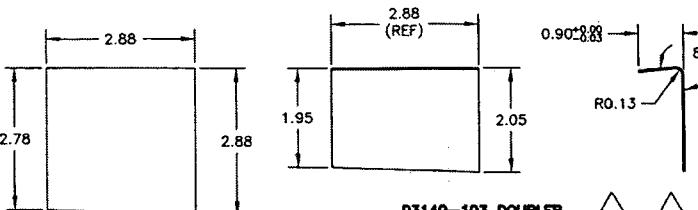
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D3140-87 DOUBLER 4
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER 4
D3140-106 OPPOSITE D

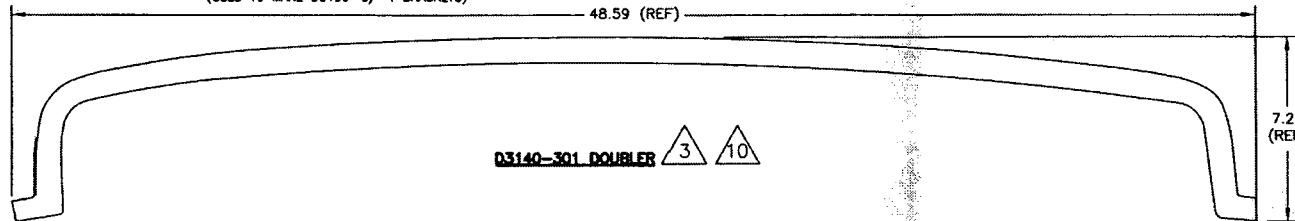


D3140-103 DOUBLER
D3140-104 OPPOSITE 4 D

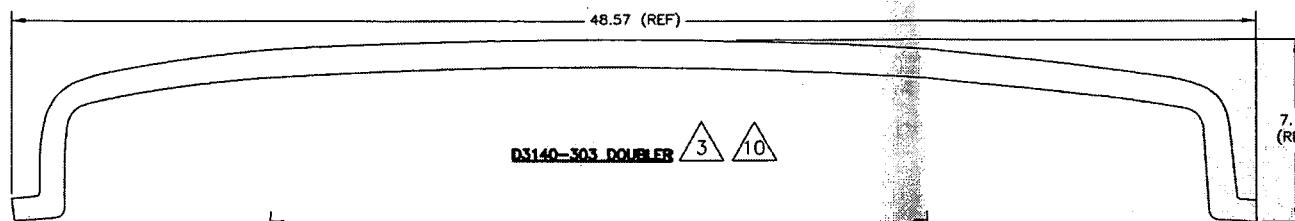
D3159-3F FLAT PATTERN

(USED TO MAKE D3159-3/4 BRACKETS)

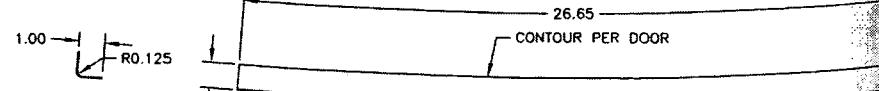
48.59 (REF)



D3140-301 DOUBLER 3 10



D3140-303 DOUBLER 3 10



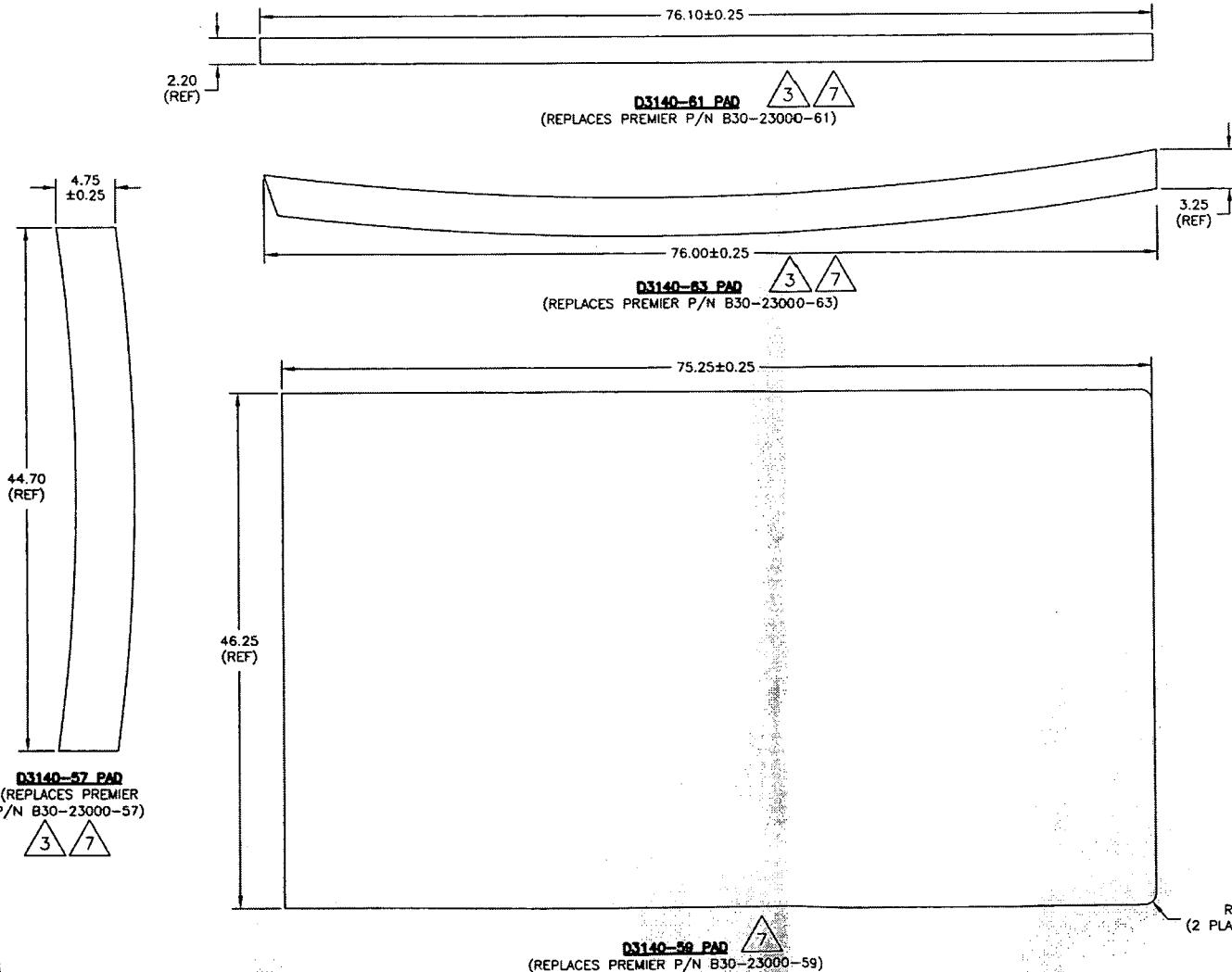
D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.00"
(REPLACES PREMIER P/N B30-23000-85)

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D3140-241 DOUBLER (5)
(REPLACES PREMIER P/N B30-23000-241)

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